

Work Order ID 149746 - ~~149746~~
Thursday, July 28, 2016 8:30:52 AM
-3 split.

149746

Page 1

Item ID: D2646

Accept

Revision ID:

N900040100

Setup Start *NS1*

Item Name: Aft Cap

Stop *NS2*

Start Date: 7/28/2016 Start Qty: 10.00

Required Date: 7/28/2016 Req'd Qty: 10.00

Reference: drab green

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

Draw Nbr

Revision Nbr

D2646

Rev C

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.03

Hand Finishing

155

155

SprayPaint

0.00

Spray Painting

Memo

0.00

PULL FROM STOCK

8 X D2646 B136885

2 x D2646 B141214

SCUFF LIGHTLY

PRIME B 135654

SRPAY PAINT DRAB GREEN B 135836

DRAB GREEN

6 L

23.10.16

Work Order ID 149746

Thursday, July 28, 2016 8:30:52 AM

149746

Page 2

Item ID: D2646

Revision ID:

Item Name: Aft Cap

Start Date: 7/28/2016 Start Qty: 10.00

Required Date: 7/28/2016 Req'd Qty: 10.00

Reference: drab green

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

175

QC14- Inspect Spray Paint

0.00

175

QC

Memo

0.00

Quality Control

OCT 24 2016

180

180

Small Fab

Small Fab

0.00

Memo

0.05

Small Fab

Install inserts as per Dwg D2646

190

190

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.03

11/16/27

6 of 16-10-24

DAS 34 9-89

Work Order ID 149746

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149746

Page 3

Item ID: D2646

Revision ID:

Item Name: Aft Cap

Start Date: 7/28/2016 Start Qty: 10.00

Required Date: 7/28/2016 Req'd Qty: 10.00

Reference: drab green

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

200

Identify as per dwg & Stock Location: FP-001

0.00

200

Packaging

Memo

0.02

Packaging

LOCATION : FP001

x6 d Ill 16/10/26

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.17

Quality Control

16/10/25

DAS
21
9-00

OCT 25 2016

Picklist Print

Thursday, July 28, 2016 8:30:52 AM

Page 1

Work Order ID: 149746

Parent Item: D2646

Parent Item Name: Aft Cap

149746

D2646

Start Date: 7/28/2016

Required Date: 7/28/2016

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: G05.08.22Hole size revised in Step 5KJ/JLM
IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

AELS8-1032-130

Purchased

No

Each

1,262.000

~~28~~ 12

**

all 16/10/201

AI S7-1032-130

Rivnut

Location

Loc Qty

Loc Code

FG

100

M128649

100

FP001

13

M128649

13

st549

1149

M128649

1149

Each

37.0000

10

**

D2646

Manufactured

No

D2646

Aft Cap

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

33

127924

1

136885

2

141214

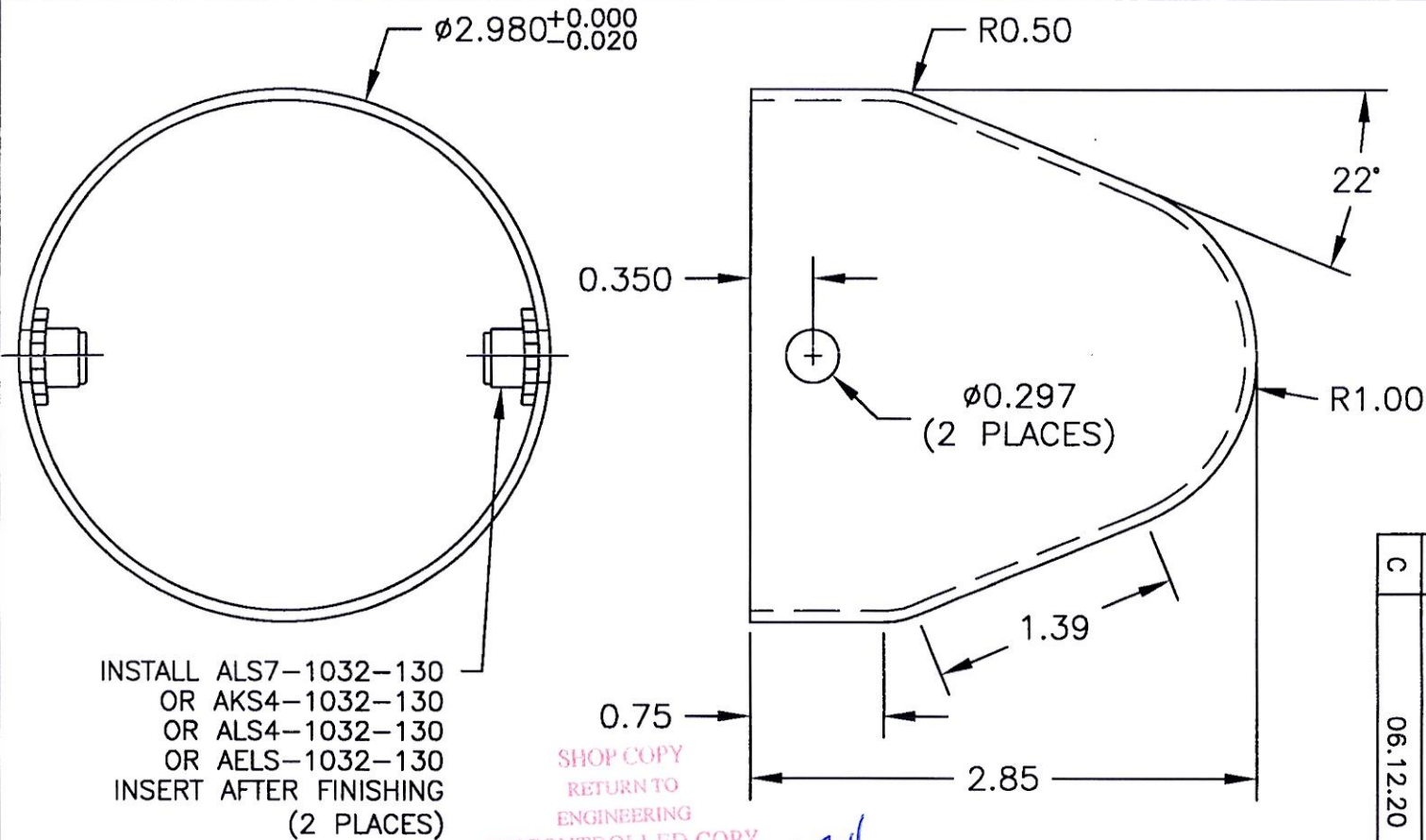
30

8

16.07.28

DART

DESIGN	DS	DRAWN BY AH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	AK	APPROVED AK	DRAWING NO. D2646	REV. C SHEET 1 OF 1
DATE	06.12.20		TITLE AFT CAP	SCALE 1:1
A	97.03.25		NEW ISSUE	
B	05.04.01		CHANGE TO CLOSED INSERTS	
C	06.12.20		CHANGE TO OPEN ENDED INSERTS	



INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~149272~~ M

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

07.02.12

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